

Work Order ID 72698

Monday, August 08, 2011 2:40:35 PM

Harvey



PRELIMINARY ISSUE

Page 1

Item ID: D4421-5

Accept



Setup Start



Revision ID: PRELIM

Item Name: Upper Curve

Stop



Start Date: 8/12/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 8/12/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

*[Signature]*

Date: 11-08-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4421	PA 13 11.08.23								
100		0.00							
	Waterjet								
	FLOW CNC Waterjet								
	341.050								
	Memo	0.00							
	1-Cut as per Dwg								
	Dwg Rev: PA2								
	Prog Rev: P12								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC								
	Quality Control								
	Memo	0.00							

B1-8-8

3

FB1-8-8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Item ID: D4421-5	Accept		Setup Start	
Revision ID: PRELIM			Stop	
Item Name: Upper Curve				
Start Date: 8/12/2011	Start Qty: 2.00		Cust Item ID:	
Required Date: 8/12/2011	Req'd Qty: 2.00		Customer:	
Reference:				

Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run Start	
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 0.00	- inspected to PM 1 Day only 8/10/11 (43)						
130  Brake NC Brake NC	Form as per dwg  Memo	0.00 0.00							(3) 8/11/11-16
140  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00	- inspected to PM 1 Day only 8/10/11 (43)						

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 72698

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Item ID: D4421-5	Accept		Setup Start	
Revision ID: PRELIM			Stop	
Item Name: Upper Curve				
Start Date: 8/12/2011	Start Qty: 2.00		Cust Item ID:	
Required Date: 8/12/2011	Req'd Qty: 2.00		Customer:	
Reference:				

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run Start	
	QC:	Date:	SPC (Y/N):	Date:	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location.	0.00							
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

1 left

QC 11.08.23

RD23341

11.08.24

POSITIVE RECALL

EFFECTIVE \_\_\_\_\_ AUTH \_\_\_\_\_  
RELEASED MP DATE 11/16/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 1

Monday, August 08, 2011 2:40:41 PM

Work Order ID: 72698



Parent Item: D4421-5



Parent Item Name: Upper Curve



Start Date: 8/12/2011

Required Date: 8/12/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 11.08.05 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA  304/316 .050 Sheet		Purchased	No			100	sf	234.6550	0.3817	0.803579	1.5		
										BI-8-8			

Location

Loc Qty

Loc Code

MAT020

82.655

113062

13.655

116979

69

MAT021

152

118217

152

113062

(3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

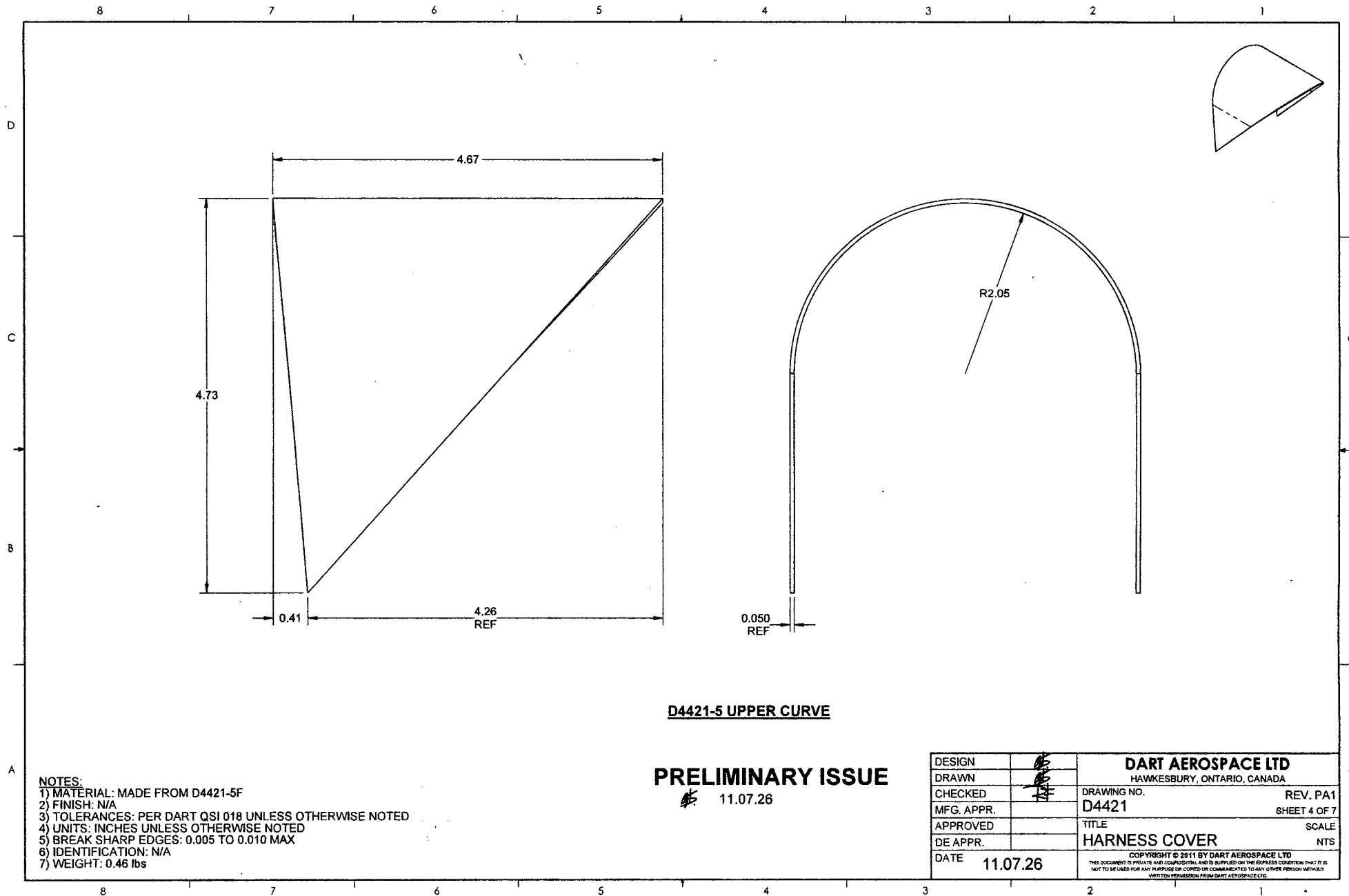
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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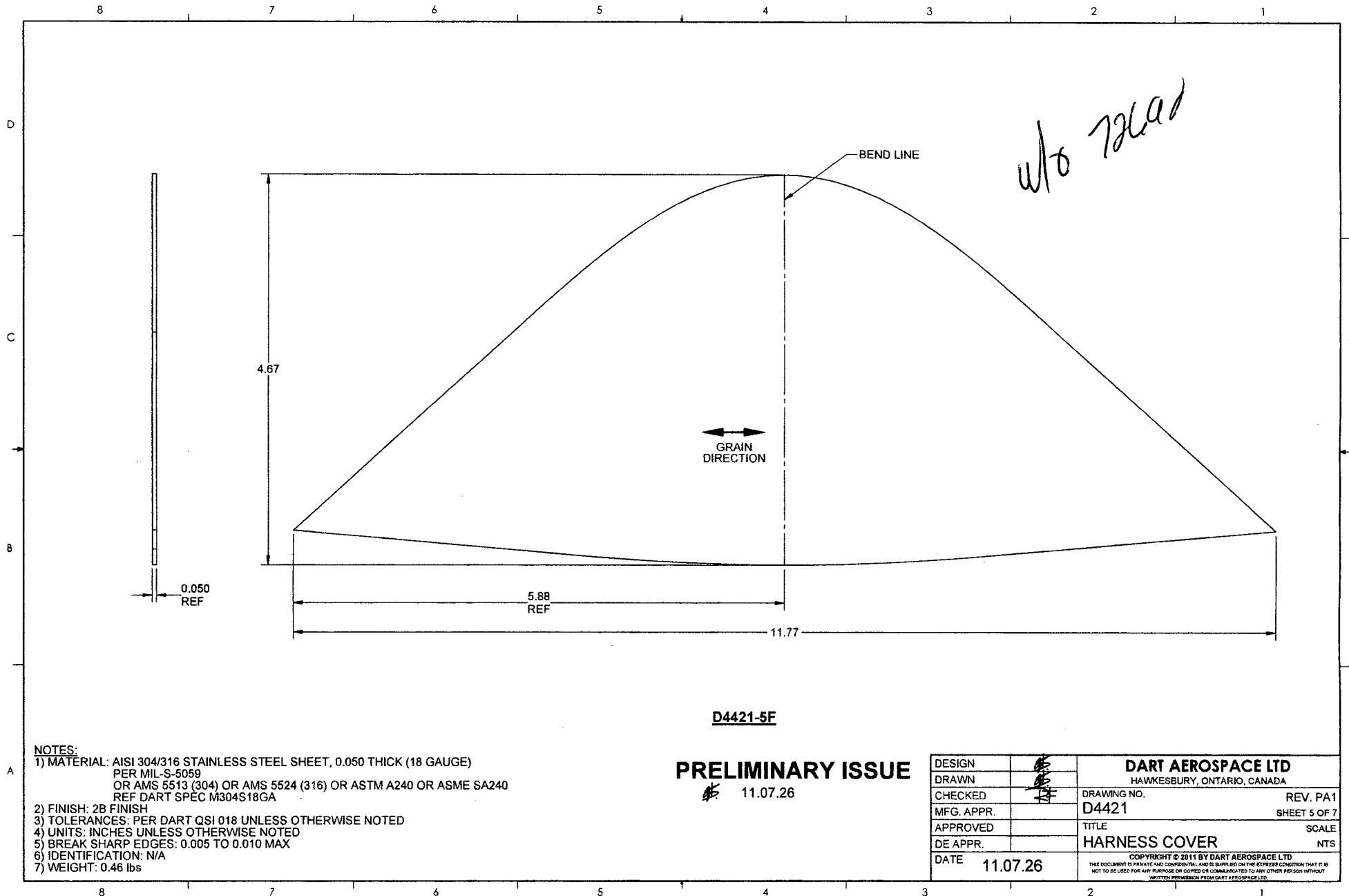
**D4421-5 UPPER CURVE**

**PRELIMINARY ISSUE**

11.07.26

- NOTES:**
- 1) MATERIAL: MADE FROM D4421-5F
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.46 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA1
MFG. APPR.		<b>D4421</b>	SHEET 4 OF 7
APPROVED		TITLE	SCALE
DE APPR.		<b>HARNES COVER</b>	NTS
DATE	<b>11.07.26</b>	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	






D4421-5F

PRELIMINARY ISSUE

11.07.26

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.050 THICK (18 GAUGE)  
PER MIL-S-5059  
OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240  
REF DART SPEC M304S18GA
- 2) FINISH: 2B FINISH
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.46 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA
MFG. APPR.		D4421	SHEET 5 OF
APPROVED		TITLE	SCALE
DE APPR.		HARNES COVER	NTS
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